W	Jork	Or	der	ID	621	71

Page 1

Monday, September 20, 2010 10:17:21 AM

Item ID:

D3686-041

Accept



Setup Start



Stop

Revision ID:

Item Name:

Required Date: 10/1/2010

MONOPOD ASSEMBLY

Start Date:

9/20/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: _____

Date: 10-9-20 Tooling:

SPC (Y/N):

Date: Date:

Run

Stop

Start

Sequence ID/ **Work Center ID** Operation

QC:

Revision Nbr

Pick Kit

Rev D

Set Up/

Tool # Plan

Accept

Reject

Reject Insp.

Draw Nbr

Description

Run Hours

Tool ID

Code Qty Qty

Number

Stamp

D3686

100

Packaging

Memo

0.00

0.00

Packaging

110

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivelent on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 &D3693-3 &D3688-7 Using Sikaflex -241/-

291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

Dart Ae	rospace	Ltd								• 1
W/O:			W	ORK ORDER CHANGI	ES	, , , , , , , , , , , , , , , , , , , 				
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	egory:	_ NCF	R: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	on:	_ QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE	(NCR)			
		Description of NC	Corrective Action Section				Verification		Approval	Approval
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng			Sign & Date		ion C	Chief Eng	QC Inspector
										1
		·								

Work Order ID 62171

Quality Control

Page 2

Monday, September 20, 2010 10:17:21 AM Item ID: D3686-041 Accept Setup Start **Revision ID:** Stop Item Name: MONOPOD ASSEMBLY Start Oty: 1.00 Start Date: 9/20/2010 Cust Item ID: Required Date: 10/1/2010 **Req'd Qty:** 1.00 **Customer:** Reference: Start Run Process Plan: Tooling: Date: Date: Approvals: Stop Date: SPC (Y/N): Date: Sequence ID/ Reject Set Up/ Tool ID Reject Insp. Operation Tool # Plan Accept Work Center ID Qty Otv Description Number Stamp Run Hours Code 120 OC5- Inspect part completeness to step on W/O dwlash, Memo Quality Control Identify as per dwg & Stock Location 30 130 0.00 Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

10/09/22/XJ MF 10-9-22

Dart Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			· · · · · · · · · · · · · · · · · · ·							
Part No		PAR #:	Fault Cate	gory:		No DQA:	Date: _			
			QA: N/C [,] Closed: Date:							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR) , 44.3,				
DATE	STEP	Description of NC	1-141-1		tion B	Verification	Approval	Approval		
	0,	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector		
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Picklist Print

Monday, September 20, 2010 10:17:21 AM

Work Order ID: 62171

D3686-041

Parent Item Name:

MONOPOD ASSEMBLY



Start Date: 9/20/2010

Required Date: 10/1/2010

Start Oty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:A new issue 08-02-12 DD verified by:JLM

IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IPP

IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3688-7		Manufactured	No			110	Each	8.0000	1	4	10/09	20
	·				44686	<u>Loc (</u>	8 1	Loc Code	<u>/</u>		- -	
D3689-1		Manufactured	No		50931	110	7 Each	13.0000	1	1 Efg	5/0/	bg /20
					56335 58634	<u>Loc (</u>	Dty 13 1 12	Loc Code	_		- -	·
D3691-1		Manufactured	No			110	Each	15.0000	1 	1	Z(0)	169/20
				Location ST082	58631	<u>Loc (</u>	Oty 15 15	Loc Code	<u>-</u>		- -	

Dart Aerospace

W/O:			W	ORK ORDER CHANG	ES									
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	•	PAR #:	Fault Cat	egory:	_ NCF	R: Yes	No DQ	A:	Date:					
			olution: Disposition: G											
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE	(NCR)		÷					
DATE	STEP	Description of NC Corrective Action			tion B		Verific	ation	Approval	Approval				
DAIL	SIEF	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector				
		;								•				
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				•										

Monday, September 20, 2010 10:17:21 AM

Work Order ID: 62171

Parent Item:

D3686-041

Parent Item Name: MONOPOD ASSEMBLY



Location

Location

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

D3692-1
1 000

SPACER

Manufactured	N

Manufactured

110

Each 349.0000

D3692-3



D3693-1

D3693-3

AN3C10A

ST082	349
51467	349
	 -

110

110

110

45.0000 Each

SPACER

Manufactured No

Manufactured

No

No

ST082 44690 45 45

Loc Qty

Loc Oty

Loc Code

Loc Code

Each 40.0000

Rod End Bearing

Location ST082

50734

50723

Loc Qty 40

Loc Code

40

Rod End Bearing

Location ST082

Loc Oty

Each

Loc Code

6.0000

36.0000

Bolt

Purchased No 110 Each

Loc Qty Loc Code Location ST351 ; 36 105940 16 112489 20

Q

Dart Aerospace Ltd

W/O:			1/1	ORK ORDER	CHANCES	<u></u>							
DATE	STEP	PRO	OCEDURE CH		CHANGES	Ву	Date	Qty	Approval Chief Eng /	Approval			
	0.1.						Duto	<u> </u>	Prod Mgr	QC Inspector			
										·			
Part No		PAR #:	Fault Cat	tegory:		NCR: Yes	No DQA	\ :	Date: _				
	R	esolution:	Disposit	ion:		QA: N/C Closed: Date:							
NCR:		1	WORK ORI	DER NON-CO	NFORMAN	CE (NCR	()		**.				
DATE	CTED	Description of NC	Description of NC Corrective Action			3	Verifica	ation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng		escription f Eng	Sign & Section C	Chief Eng	QC Inspector					
,													
						,							
				-									

Monday, September 20, 2010 10:17:21 AM

Work Order ID: 62171

Parent Item:

D3686-041

Parent Item Name: MONOPOD ASSEMBLY



Start Date: 9/20/2010

Required Date: 10/1/2010

Start Otv: 1.00

Required Oty: 1.00

AN3C12A

Bolts

Purchased

Purchased

No

No

Each

86.0000

Loc Otv Loc Code Location ST351 86 112314 8 114761 11 115392 47 20 115594 2,643.000 110 Each

110

MS21043-3

Nut

NAS509L12C

Location		Loc Qty	Loc Code
FG	•	76	
	103691	76	
ST301		2567	
	109147	4	
	111383	46	
	112314	2517	

110

Each

Loc Qty

51

41

10

No Purchased

Nuts

Location ST280 112314 112828 Loc Code

51.0000

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W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:			QA: N/C Closed:			Date: _			
NCR:		\	WORK ORD	R NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC			ion B Ve		rification Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section of		Chief Eng	QC Inspector
					:				-1
				·					

Picklist Print

Monday, September 20, 2010 10:17:21 AM

Work Order ID: 62171

Parent Item:

D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 9/20/2010

Required Date: 10/1/2010

Page 4

Start Qty: 1.00

Required Oty: 1.00

NAS509-12C

Purchased

110

46.0000 Each

46

46

Loc Code

Nuts

Location Loc Qty ST280

112453

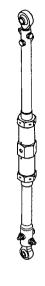
Dart Aerospace Lt

W/O:			WC	ORK ORDER CHANG	FS			
DATE	STEP	PROCEDURE CHANGE			Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA: _	Date:	
	Re	solution:	Disposition	n:	_ QA: N/C Cld	osed:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR) :::::::::::::::::::::::::::::::::::::		
DATE	OTED	Description of NC Corrective Action Sec			on B	Verificati	on Approval	Approval
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (C Chief Eng	QC Inspector	

QTY -041 ITEM PART NUMBER DESCRIPTION D3686-041 MONOPOD ASSEMBLY STUD SLEEVE 03691-1 STUD D3692-1 SPACER D3692-3 SPACER D3693-1 ROD END BEARING ROD END BEARING D3693-3 AN3C-10A BOLT 10 AN3C-12A BOLT 11 MS21043-3 NUT 12 NAS509L-12C NUT 13 NAS509-12C

D3693-3 ROD END BEARING -AN3C-10A BOLT D3692-3 SPACER, 2X MS21043-3 NUT 4 -D3688-7 STUD 7.25 REF -NAS509L-12C NUT 19.98 REF -D3689-1 SLEEVE 18.95 18.95 A -NAS509-12C NUT -D3691-1 STUD -ÁN3C-12A BOLT D3692-1 SPACER, 2X MS21043-3 NUT 2 PL D3693-1 ROD END BEARING 8>

62171



D3686-041 MONOPOD ASSEMBLY

8

NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED
3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

5) WEIGHT. 20 IDS 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD 7) TORQUE FASTENERS TO 20-25 in-lbs 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

£ 6 .

		46	
D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
С	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF1	08.12.15
В	REFORMATTED TO CURRENT DWG STANDARDS	1, 3	08.11.24
Α	NEW ISSUE	RF.	08.05.22
REV.	DESCRIPTION	BY	DATE

DEGIGIA	I INF	DAKI AEKOSPACE	LID			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA				
CHECKED	# 1	DRAWING NO.	REV. D			
MFG. APPR.	011	D3686	SHEET 1 OF 1			
APPROVED	-#-	TITLE	SCALE			
DE APPR.	#-	MONOPOD ASSEMBLY	NTS			
DATE 10.	03.03	COPYRIGHT © 2008 BY DART AEROSPA THIS DOCUMENT IS PROVIDE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXP	RESS CONDITION THAT IT IS			

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W/O:			٧	ORK ORDER	CHANGES	<u> </u>			
DATE	STEP	PROCEDURE CHANGE			Ву	Date (Approva Chief Eng Prod Mgr	Approval QC Inspector	
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Part No		PAR #:							
	Res	solution:						Date:	
NCR:		W	ORK OR	DER NON-CO	NFORMAN	CE (NCR)		
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description				Sign & Verification		al Approval
		Section A	Chief Eng	Chief		Date	Section	C Chief Eng	QC Inspector
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